

Tuesday, 10/04/2007 7:32:31 AM
Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET, GAS SPRING STUD
Job Number	: 31688		
Estimate Number	: 10183		
P.O. Number	: N/A	Part Number	: D2154
This Issue	: 10/04/2007 S.O. No. : N/A	Drawing Number	: D2154 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 31688	Material	: N/A
Written By	: <u>W</u>	Due Date	: 19/04/2007
Checked & Approved By	: <u>W</u>	Qty:	24 Um: Each
Comment	: Est: C 03.08.08 Reformat; Remove Tumble KJ/RF Est Rev:D NowOn Waterjet 07-04-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.0350 sf(s)/Unit Total : 0.6993 sf(s)

304/316 .063 Sheet

Batch: M103961

SAP 07/04/14 24

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2154

Dwg Rev: EProg Rev: E

2-Deburr if necessary

→ Wm 07/04/20
SAP 07/04/14

(24)

24

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAP 07/04/14

24

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAP 07/04/15

24

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

N/A

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, GAS SPRING STUD

Job Number: 31688

Part Number: D2154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154

Rev: C

SD 07/04/23 (24)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-04-24 (24)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

MI 103 706

07-04-26 (24)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07-04-27 (24)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5716

07-04-27 (24)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07-04-27

Job Completion



U 07-04-27

Date: Thursday, 4/5/2007 11:58:50 AM
User: Kim Johnston



Process Sheet



Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET, GAS SPRING STUD
Job Number : 31688	
Estimate Number : 10183	
P.O. Number :	Part Number : D2154
This Issue : 4/5/2007 S.O. No. :	Drawing Number : D2154 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 27126	Material :
Written By :	Due Date : 4/19/2007 Qty: 20 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: C 0308.08 Reformat; Remove Tumble KJ/RF	



Additional Product



Job Number: 



Seq. #	Machine Or Operation:	Description :
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1.0000	PG	PURCHASING		
<p><i>M30/S 166A</i> <i>SF 333</i> <i>water jet</i></p>				
<p>Comment: PURCHASING Issue P/O: _____ Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D2154 Material release note is required</p>				

2.0000	D2154F	Bracket, Stud		
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) BRACKET, GAS SPRING STUD</p>				

3.0000	PACKAGING 1	PACKAGING RESOURCE #1		
<p>Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached</p>				

4.0000	QC6	DIMENSIONAL CHECK		
<p>Comment: DIMENSIONAL CHECK</p>				

5.0000	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1		
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary</p>				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:58:50 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET, GAS SPRING STUD

Job Number: 31688

Part Number: D2154

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2154

Rev: _____

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

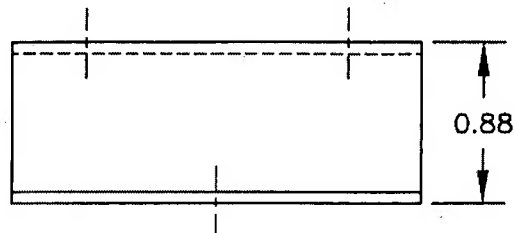
NOTE: Date & initial all entries



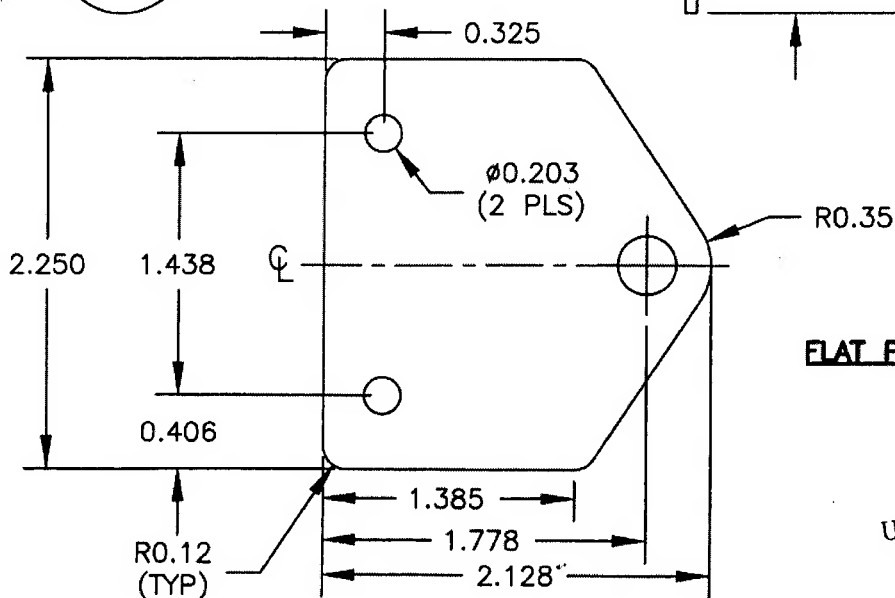
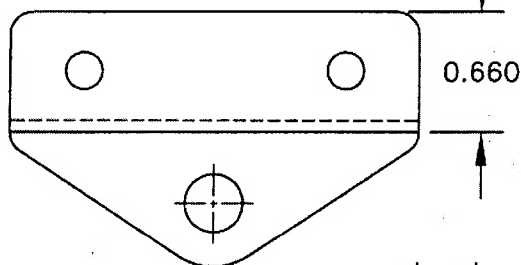
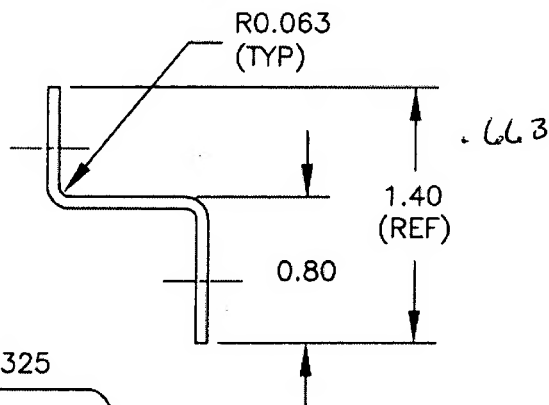
DESIGN GH	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2154	REV. C SHEET 1 OF 1
DATE 04.10.12	TITLE BRACKET, STUD		SCALE 1:1
A	92.07.28	NEW ISSUE	
B	98.09.15	UPDATE FLAT PATTERN; ADD P/COAT	
C	04.10.12	0.88 WAS 0.875; 2.128 WAS 2.068	

RELEASED

04.10.15 *[Signature]*



BEND DETAIL



FLAT PATTERN

D2154 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)
2B FINISH 0.063 THICK (M304S16GA)
- 2) FINISH: POWDER COAT WHITE (REF: 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH PART NUMBER AND BATCH NUMBER USING A FINE POINT PERMANENT INK MARKER.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31688

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DART AEROSPACE LTD		Work Order: 31688
Description:		Part Number: D2154
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 2.250	+/- 0.010	2.255	✓		Vern	
B 1.438	+/- 0.010	1.439	✓		Vern	
C 0.406	+/- 0.010	0.408	✓		Vern	
D 1.778	+/- 0.010	1.782	✓		Vern	
E 2.128	+/- 0.010	2.130	✓		Vern	
F 0.325	+/- 0.010	0.327	✓		Vern	
G Ø 0.203	+/- 0.005 0.001	Ø 0.204	✓		Vern	
H 0.063	+/- 0.010	0.058	✓		Vern	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: [Signature]	Prototype Approval:	N/A
Date: 07/04/14	Date: 07/04/14	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved